



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G13831-3G
Job Sheet 189619



Part No: RBW6205G13831-3G

Job Qty: 1 pcs

Part Name: AW139 Swashplate Box 2



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/29/19

Job Tracking No:

Due Date: 4/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G13831-3G REV 2 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	4/15/19		0.00	0.00	Small Fab - 1		
							Small Fab - 2		MLC
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	Small Fab - 2 - B4B	1 pcs	4/15/19		0.00	1.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		MLC
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
120	QC 5	1 pcs	4/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		Pd 18.02.22
							QC 5 - 50		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S154885



Part: RBW6205G13831-3G

Job No: 189619

Serial No/Batch: S154885

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 02/19/19

Plex 2/12/19 9:21 AM Dart.Hadley.Shannon

				QC 5 - 30	
130 Packaging 3-1 - Stock - B4B 1 pcs	4/15/19	0.00 0.00	Packaging 3 - 1 - B4B		
			Packaging 3 - 2 - B4B		
			Packaging 3 - 3 - B4B		
			Packaging 3 - 4 - B4B		
			Packaging 3 - 5 - B4B	DAS	
			Packaging 3 - 6 - B4B	20	
			Packaging 3 - 7 - B4B	9-89	
			Packaging 3 - 8 - B4B		
			Packaging 3 - 9 - B4B		
			Packaging 3 - 10 - B4B		
			Packaging 3 - 11 - B4B		
			Packaging 3 - 12 - B4B		
			Packaging 3 - 13 - B4B		
			Packaging 3 - 14 - B4B		
			Packaging 3 - 15 - B4B		
			Packaging 3 - 16 - B4B		
			Packaging 3 - 17 - B4B		
			Packaging 3 - 18 - B4B		
			Packaging 3 - 19 - B4B		
			Packaging 3 - 20 - B4B		
			Packaging 3 - 21 - B4B		
			Packaging 3 - 22 - B4B		
			Packaging 3 - 23 - B4B		
			Packaging 3 - 24 - B4B		
			Packaging 3 - 25 - B4B		
			Packaging 3 - 26 - B4B		
			Packaging 3 - 27 - B4B		
			Packaging 3 - 28 - B4B		
			Packaging 3 - 29 - B4B		
			Packaging 3 - 30 - B4B		
			Packaging 3 - 31 - B4B		
			Packaging 3 - 32 - B4B		
			Packaging 3 - 33 - B4B		
			Packaging 3 - 34 - B4B		
			Packaging 3 - 35 - B4B		
			Packaging 3 - 36 - B4B		
140 QC 21 - FG 1 pcs	4/15/19	0.00 0.00	QC 21 - FG - 21	DAS	
			QC 21 - FG - 70	21	
Part Op 100 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Descriptions: Pelican case APP-1600-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6205G13831-3G-9 to RBW6205G13831-3G-7 foam as per DWG. 6-Glue foam to case and pack case as per DWG. 110 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1600-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBW6205G13831-3G-9 to RBW6205G13831-3G-7 foam as per DWG. 6-Glue foam to case and pack case as per DWG. 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)					

DAS
23
9-89

GA212

DAS
21
9-89

FEB 25 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1600-E 128B	Case	1 Ea (1 ea)	100-Small Fab - 1	5124783
3777T12 28	Spring Catch	2 Ea (2 ea)	110-Small Fab - 2 - B4B	5157939
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab - 2 - B4B	5113449
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5021040
RBW6205G12731-3G 161	Upper Plate Assembly	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5134667
RBW6205G13151-3G 138	Lower Plate	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5134643
146B RBW6205G13231-3G	Arm Assembly	3 pcs (3 ea)	110-Small Fab - 2 - B4B	5134635
95 RBW6205G13531-3G	Screw Assembly	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5139638
RBW6205G13831-3G-1	Shelf Backing	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5139638
151 RBW6205G13831-3G-11	Dynamometer	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5091460
128B RBW6205G13831-3G-3	Shelf	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5124787
128B RBW6205G13831-3G-5	Bottom Foam use in case APP-1600-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5124785
128B RBW6205G13831-3G-7	Lid Foam use in case APP-1600-E	1 Ea (1 ea)	110-Small Fab - 2 - B4B	5124789
98 RBW6205G13831-3G-9	Location Placard	1 pcs (1 ea)	110-Small Fab - 2 - B4B	5138476

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	APP-1600-E	1	7	0
110-Small Fab - 2 - B4B	3777T12	2	6	0
	97524A032	4	514	0
	RB41011	1	417	0
	RBW6205G12731-3G	1	2	0
	RBW6205G13151-3G	1	7	0
	RBW6205G13231-3G	3	6	0
	RBW6205G13531-3G	1	2	0
	RBW6205G13831-3G-1	1	2	0
	RBW6205G13831-3G-11	1	4	0
	RBW6205G13831-3G-3	1	2	0
	RBW6205G13831-3G-5	1	4	0
	RBW6205G13831-3G-7	1	4	0
	RBW6205G13831-3G-9	1	2	0

Part Specifications

Specifications could not be found.

Plex 2/12/19 9:21 AM Dart.Hadley.Shannon



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							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	4/1/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

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					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	4/1/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	

Part Op 110 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into
 Descriptions: Pelican case APP-1600-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue
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 DWG.

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location:_____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3777T12	Spring Catch	2 Ea (2 ea)	110-Small Fab - 1	
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	110-Small Fab - 1	
APP-1600-E	Case	1 Ea (1 ea)	110-Small Fab - 1	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	110-Small Fab - 1	
RBW6205G12731-3G	Upper Plate Assembly	1 pcs (1 ea)	110-Small Fab - 1	
RBW6205G13151-3G	Lower Plate	1 Ea (1 ea)	110-Small Fab - 1	
RBW6205G13231-3G	Arm Assembly	3 pcs (3 ea)	110-Small Fab - 1	
RBW6205G13531-3G	Screw Assembly	1 pcs (1 ea)	110-Small Fab - 1	
RBW6205G13831-3G-1	Shelf Backing	1 Ea (1 ea)	110-Small Fab - 1	
RBW6205G13831-3G-11	Dynamometer	1 pcs (1 ea)	110-Small Fab - 1	
RBW6205G13831-3G-3	Shelf	1 Ea (1 ea)	110-Small Fab - 1	
RBW6205G13831-3G-5	Bottom Foam use in case APP-1600-E	1 Ea (1 ea)	110-Small Fab - 1	
RBW6205G13831-3G-7	Lid Foam use in case APP-1600-E	1 Ea (1 ea)	110-Small Fab - 1	
RBW6205G13831-3G-9	Location Placard	1 pcs (1 ea)	110-Small Fab - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Small Fab - 1	3777T12	2	4	0
	97524A032	4	723	0
	APP-1600-E	1	7	0
	RB41011	1	478	0
	RBW6205G12731-3G	1	2	0
	RBW6205G13151-3G	1	7	0
	RBW6205G13231-3G	3	6	0
	RBW6205G13531-3G	1	2	0
	RBW6205G13831-3G-1	1	2	0
	RBW6205G13831-3G-11	1	4	0
	RBW6205G13831-3G-3	1	2	0
	RBW6205G13831-3G-5	1	4	0
	RBW6205G13831-3G-7	1	4	0
	RBW6205G13831-3G-9	1	2	0

Part Specifications

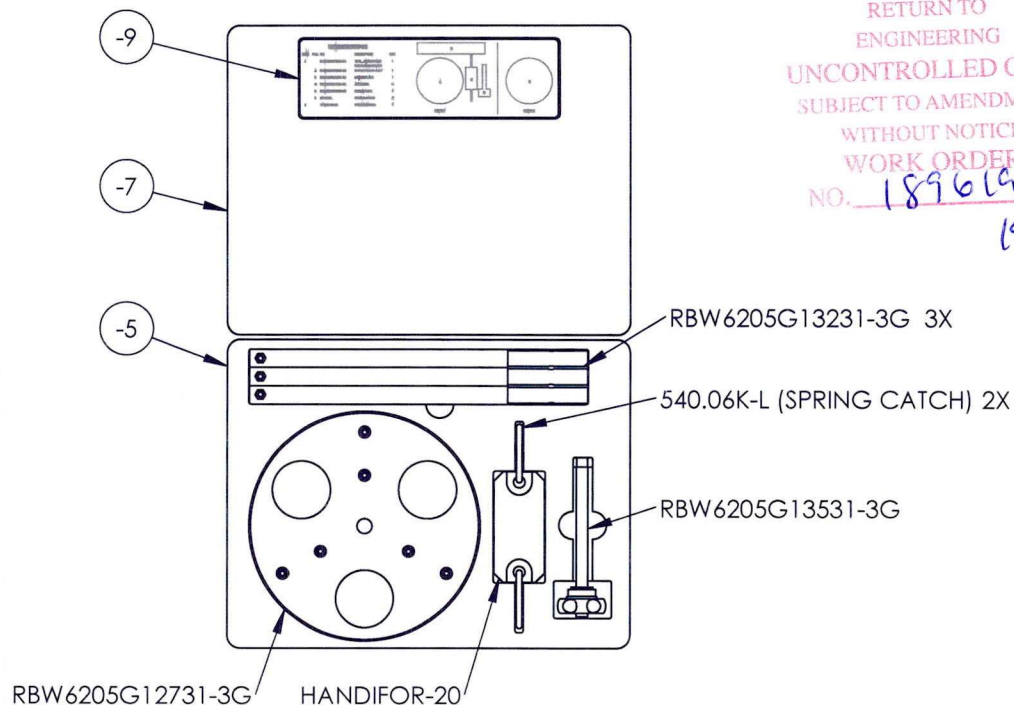
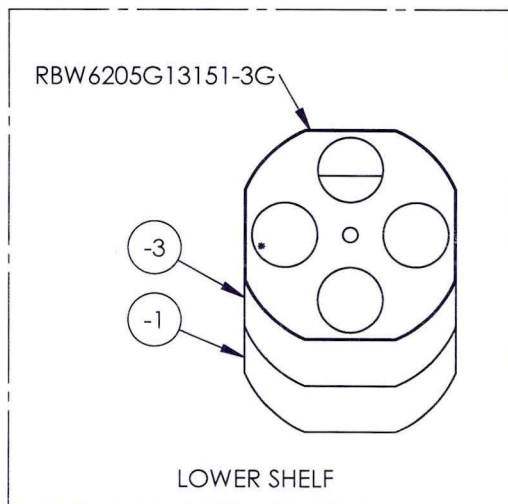
Specifications could not be found.

Plex 1/29/19 8:40 AM Dart.lajeunesse.marie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-1 & -3 ADDED NOTE. -5 CH'D OVERALL DIMENSIONS TO FIT CASE TIGHTER. -7 CH'D OVERALL DIMENSIONS TO FIT CASE TIGHTER, CH'D CUTOUT TO RECESSED POCKET ADDED CUTOUT ON BOTTOM FOR CASE PIN CLEARANCES AND MATERIAL FROM C200 FLAT TO 1780 FLAT BLACK.	6/29/2011	RJC	RW
2	15-0151	-5 CH'D CUTOUT SIZE AND DEPTH FOR -11 & -13, CH'D DIM WAS ∇ 1.00 IS ∇ 1.60 FOR RBW6205G13231-3G. -7 CH'D FOAM WAS 1780 FLAT, BLACK IS Y20 BLACK, CH'D CUTOUT DEPTH FOR PLACARD WAS .063 IS .13. -9 REMOVED TEXT "CONTENT LIST", CH'D DESCRIPTION WAS PLACARD IS LOCATION PLACARD.	7/8/2015	RJC	JAG

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 189619 MLS
15-01-29



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	UPPER PLATE ASSEMBLY		RBW6205G12731-3G	1
				1	LOWER PLATE		RBW6205G13151-3G	1
				3	ARM ASSEMBLY		RBW6205G13231-3G	1
				1	SCREW ASSEMBLY		RBW6205G13531-3G	1
		B/O	-1	1	SHELF BACKING	COROPLAST	BLACK, 6mm Ø12-7/16 I.R. SPECIALTY	2
		B/O	-3	1	SHELF	Y20 BLACK	Ø12-7/16 X 13/16	3
		B/O	-5	1	BOTTOM FOAM	Y20 BLACK	6-1/8 X 16-3/4 X 21-3/4 I.R. SPECIALTY	4
		B/O	-7	1	LID FOAM	Y20 BLACK	1-3/4 X 16-3/8 X 21-5/16 I.R. SPECIALTY	5
			-9	1	LOCATION PLACARD	PLASTIC		6
		B/O	-11	1	DYNAMOMETER		HANDIFOR-20	1
		B/O	-13	2	SPRING CATCH	S.S.	Ø5/16 CARABINER STYLE (MCMASTER-CARR #3777112)	1
		B/O	-15	1	CASE	PLASTIC, BLACK	8 X 17 X 22 PELICAN #APP-1600-E	N/S
		B/O	-17	1	DART PLACARD	ALUMINUM	#RB41011	N/S

NOTE:
PART OF KIT RBW6205G11231-3G.

DART AEROSPACE	
TITLE AW139 SWASHPLATE KIT	
DWG NO. RBW6205G13831-3G	
REV 2	
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: CLOUGH APPROVED: D Weil HEAT TREAT FINISH SPEC USED ON MODEL AW139
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE 1:10 DATE 1/31/2011 SHEET 1 OF 6

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					